

Work Order ID 123831

Wednesday, August 27, 2014 12:57:26 PM

123831

Rev ~~3~~ C Day a b y Sub 6/13
PRELIMINARY ISSUE

Item ID: D2270-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: PRELIM Stop *NS2*
 Item Name: Raidus Block
 Start Date: 8/27/2014 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 8/29/2014 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: ME Date: 14-8-28 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2270	<u>Rev C Sub 6/13</u>								
100	SHEAR	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>801</u> Prog Rev: <u>801</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110	HAAS CNC VERTICAL MACHINING #1								
QC	Memo	0.00							
Quality Control									

DAS
46
9-89

De 14/08/27

DAS
46
9-89

De 14/08/27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Wednesday, August 27, 2014 12:57:27 PM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 8/27/2014 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 8/29/2014 **Req'd Qty:** 2.00 ***~***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
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Accept Qty	Reject Qty	Reject Number	Insp. Stamp

120

0.00

120

0.00

Mill Conv

Memo

Conventional Milling Machine

Machine CMFas per dwg D2270

Debutt

130

QC2- Inspect parts off machine FAI/FAIB

0.00

130

0.00

QC

Memo

Quality Control

140

QC8- Inspect parts - second check

0.00

140

0.00

QC

Memo

Quality Control

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123831

Page 3

Item ID: D2270-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: PRELIM Stop ***NS2***
Item Name: Raidus Block
Start Date: 8/27/2014 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 8/29/2014 Req'd Qty: 2.00 ***2*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>Dart</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

POSITIVE RECALL

EFFECTIVE 14/08/27 AUTH mf
RELEASED 5 DATE 14/09/13

to Rev C Dwg only

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Wednesday, August 27, 2014 12:57:26 PM

Page 1

Work Order ID: 123831

123831

Parent Item: D2270-1

D2270-1

Parent Item Name: Raidus Block

Start Date: 8/27/2014

Required Date: 8/29/2014

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 14.05.20 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S12GA		Purchased	No				sf	100.8300		1		DAS	
M304S12GA									**			46	
304/316 0.100" Sheet												9-89	OK 14/08/27

Location

Loc Qty

Loc Code

MAT019

100.83

113062

76.13

113077

19

m126309

5.7

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

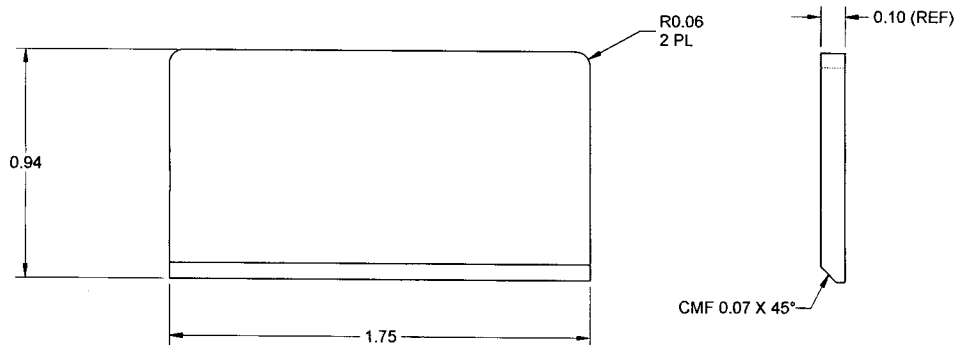
Work Order update only ☐

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Training									
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D2270-1 RADIUS BLOCK



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 12 GAUGE 0.10 THICK, (REF DART SPEC M304S12GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

D	12 GAUGE WAS 11 GAUGE	DB	14.05.21
C	304 STAINLESS STEEL WAS 6061-T6 ALUMINIUM, 0.94 WAS 0.71, 0.10 WAS 0.125, CMF 0.07 X 45° WAS R0.125	DB	14.03.11
B	REDRAWN	RF	01.06.14
A	NEW ISSUE	RF	94.09.15
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. PD1
MFG. APPR.	DD	D2270	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	RADIUS BLOCK	NTS
DATE	14.05.21	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

UNAPPROVED

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

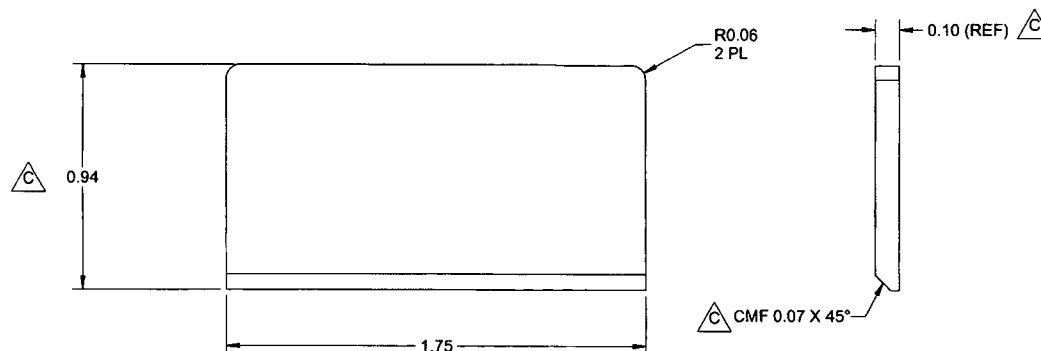
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Offset/Setup									
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FAULT CATEGORY

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D2270-1 RADIUS BLOCK

RELEASED
2014-08-27



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- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
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B	REDRAWN	RF	01.06.14
A	NEW ISSUE	RF	94.09.15
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	DD	D2270	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	RADIUS BLOCK	NTS
DATE	14.03.11	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

APPROVED

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**WORK ORDER NON-CONFORMANCE / UPDATE**

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Work Order update only ☐

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Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Receiving Report

Date: 13/2/10

Batch No: 1126309

Supplier: NECORA SOLUTION

Dart P/O: 20491

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☒ No ☐ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection 13-07-16 N/A ☒
 Work Order 13 N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 13

Production/Admin: 13/2/10
 Date
 Received/Costing 13
 Initial

Location: _____

All amounts are calculated in domestic currency.

Monday, July 15, 2013

All Vendors PO ID PO20491 Receipt Dates from 7/15/2013 to 7/15/2013 All Line Item Types

All Item ID/GL/WOs All Rec. Employees All Currencies

Grouped by Vendor ID

[illegible]

Shipping Order

11/07/2013

MÉTAUX SOLUTIONS INC
2625 BOUL JACQUES CARTIER EST
LONGUEUIL, QUEBEC
J4N 1L7 Tel : 450 641-3330

Order : 88960
Reference : 20491
Bid : 7547
Ship : PICK UP / PICK UP

Customer: 6323336

Ship To

DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKESBURY, ONTARIO
K6A 1K7

Same

Tel: 1 613 632-3336

Item No.	Description	Qty	Qty. Delivered	B/O Qty
AS03261	ALU SHE .032 6061-T6 (20G) 8 X 4' X 12' HT;36194/01	384	384	Ø
AS08081	ALU SHE .080 6061-T6 (12G) 8 X 4' X 12' HT;42000/01	384	384	Ø
AS1875	ALU SHE .125" X 48" X 144" 7075-T6 1 X 4' X 12' HT;610007A7	1	1	Ø
SS122B4	304 SHEET .104 (12G) 2 X 4' X 8' HT;C34AY1207950	64	64	Ø
	SHIP TST COLLECT JP			

Shipping : _____
Package No : _____
Merchandise Received: _____

Ref. : _____



允諾實業股份有限公司
YC INOX CO., LTD.

檢驗證明書
INSPECTION CERTIFICATE

524彰化縣溪湖鎮中山路四號270室
No.270, Sec.4, Jungshan Rd., Shijou Sheng,
Chang-Hwa, Taiwan, R.O.C
http://www.ycinox.com
TEL: +886-4-8899666 FAX: +886-4-8899770



客戶名稱 Customer	PRIME COLD ROLLED STAINLESS STEEL SHEET	客戶編號 Customer No.	FCA003	證明書編號 Certificate No.	13021800181
產品名稱 Product Name	ASTM A240/A480M-11b	商業發票號碼 Commercial Invoice No.	J13010448	證明書日期 Date of Issue	2013/02/08
規格 Specifcation	304/304L	客戶採購單號 PO No.	C86783	訂單編號 Order No.	EC12100340-2
鋼號 Steel Grade		提貨單編號 Weight No.	C13020102	PLI號碼 P.L.I. No.	A10110214

項目 Item No.	爐號 Heat No.	產品規格 Product Description				化學成份(%) Chemical Composition										拉伸試驗 Tension Test				鋼號 Steel Grade	備註 Remarks
		尺寸 Dimension	數量 Quantity	重量 Weight	表面 Finish	保護 Protect	C	Si	Mn	P	S	Cr	Ni	Mo	Co	屈服 Yield	抗拉 Tensile	伸長率 Elongation	硬度 Hardness		
1	C34AY1207060	11GA X48.0" X144.0"	10	1,058	2B	Min.	30	75	200	45	30	1750	800	1750	100	205	815	40	92	1040	
2	C34AY1207060	11GA X48.0" X144.0"	10	1,058	2B	Min.	30	75	200	45	30	1750	800	1750	100	205	815	40	92	1040	
3	C34AY1207425	11GA X48.0" X144.0"	10	1,058	2B	Min.	30	75	200	45	30	1750	800	1750	100	205	815	40	92	1040	
4	C34AY1207021	12GA X48.0" X86.0"	12	1,058	2B	Min.	30	75	200	45	30	1750	800	1750	100	205	815	40	92	1040	
5	C34AY1207050	12GA X48.0" X86.0"	12	1,058	2B	Min.	30	75	200	45	30	1750	800	1750	100	205	815	40	92	1040	
6	C34AY1207050	12GA X48.0" X86.0"	12	1,058	2B	Min.	30	75	200	45	30	1750	800	1750	100	205	815	40	92	1040	
7	C34AY1207050	12GA X48.0" X86.0"	12	1,058	2B	Min.	30	75	200	45	30	1750	800	1750	100	205	815	40	92	1040	
8	C34AY1207050	12GA X48.0" X86.0"	12	1,058	2B	Min.	30	75	200	45	30	1750	800	1750	100	205	815	40	92	1040	
9	C34AY1207050	12GA X48.0" X86.0"	12	1,058	2B	Min.	30	75	200	45	30	1750	800	1750	100	205	815	40	92	1040	
10	C34AY1207050	12GA X48.0" X86.0"	12	1,058	2B	Min.	30	75	200	45	30	1750	800	1750	100	205	815	40	92	1040	
11	C34AY1207301	14GA X48.0" X120.0"	30	1,770	2B	Min.	30	75	200	45	30	1750	800	1750	100	205	815	40	92	1040	
12	C34AY1207301	14GA X48.0" X120.0"	30	1,770	2B	Min.	30	75	200	45	30	1750	800	1750	100	205	815	40	92	1040	
13	C34AY1207301	14GA X48.0" X120.0"	30	1,770	2B	Min.	30	75	200	45	30	1750	800	1750	100	205	815	40	92	1040	
14	C34AY1207301	14GA X48.0" X120.0"	30	1,770	2B	Min.	30	75	200	45	30	1750	800	1750	100	205	815	40	92	1040	
15	C34AY1207301	14GA X48.0" X120.0"	30	1,770	2B	Min.	30	75	200	45	30	1750	800	1750	100	205	815	40	92	1040	
16	C34AY1207301	14GA X48.0" X120.0"	30	1,770	2B	Min.	30	75	200	45	30	1750	800	1750	100	205	815	40	92	1040	
17	C34BP1206017	14GA X48.0" X144.0"	12	981	2B	Min.	30	75	200	45	30	1750	800	1750	100	205	815	40	92	1040	
18	C34BP1206017	14GA X48.0" X144.0"	12	981	2B	Min.	30	75	200	45	30	1750	800	1750	100	205	815	40	92	1040	
19	C34AY1206021	14GA X48.0" X120.0"	14	981	2B	Min.	30	75	200	45	30	1750	800	1750	100	205	815	40	92	1040	
20	C34AY1206021	14GA X48.0" X120.0"	14	981	2B	Min.	30	75	200	45	30	1750	800	1750	100	205	815	40	92	1040	
TOTAL:			398	26,444																	
Visual Inspection(Surface) and Dimension Check: OK																					
Remarks: 01= Hardness Test, 02= Heat Treatment, Gauge Length: 50mm																					
Surveyor By		We hereby certify that material described herein has been manufactured and tested with satisfactory results in accordance with the requirement of the above material specification. The material described above has been delivered with free production by raw material supplier.										1MPa=1N/mm²=10bars=145psi=10.2kgf/cm²				Manager of Quality Assurance Department					
N/A																Jian Yi Guo					

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YC-2009-010



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO20491

Purchase Order Date 7/10/2013

PO Print Date 7/10/2013

Page Number 1 of 2

Order From :

VC-MET002

Ship To : DART AEROSPACE LTD

METAUX SOLUTIONS
2625 BOUL JACQUES-CARTIER EST
LONGUEUIL, QC J4N 1L7
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
6/30/10

Contact Name

Vendor Phone

800 558 8858

Ship To Contact

Ship To Phone

Ship Via:

TST ground

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

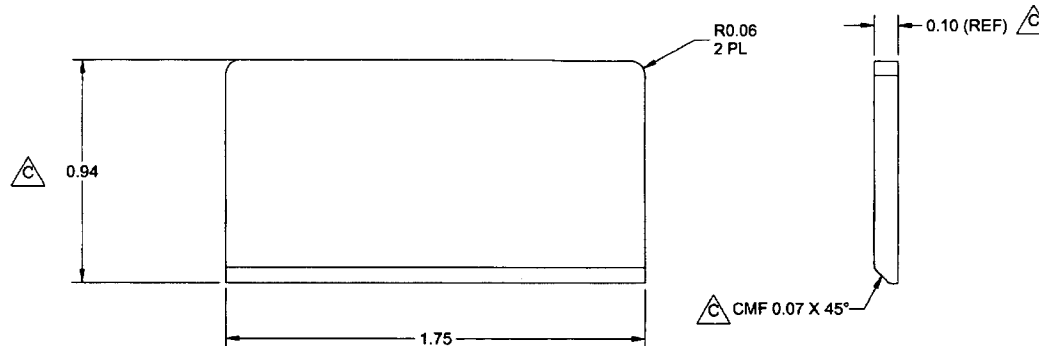
Destination-Collect

M 126 309

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	List Price	Disc %	Discounted Unit Price	Extended Price
1	M6061T6S.032	6061-T6 Sheet 0.032"	7/12/2013 Yes 7/12/2013		384.00 sf				\$806.40
MATERIAL: 6061-T6/T62 ALUMINUM SHEET AS PER QQ-A250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209									
Line Total:									\$806.40
2	M6061T6S.080	6061-T6 .080 Sheet	7/12/2013 Yes 7/12/2013		384.00 sf				\$1,670.40
SAME AS ABOVE									
Line Total:									\$1,670.40
3	M304S12GA	304/316 0.100" Sheet	7/12/2013 Yes 7/12/2013		64.00 sf				\$758.40
MATERIAL: AISI 304/316 SS SHEET ANNEALED AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240/ASME SA240									

Note:

7/10/2013



D2270-1 RADIUS BLOCK

RELEASED
2014-08-27



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 11 GAUGE 0.10 THICK, (REF DART SPEC M304S11GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

C	304 STAINLESS STEEL WAS 6061-T6 ALUMINIUM, 0.94 WAS 0.71, 0.10 WAS 0.125, CMF 0.07 X 45° WAS R0.125	DB	14.03.11
B	REDRAWN	RF	01.06.14
A	NEW ISSUE	RF	94.09.15
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	DD	D2270	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	RADIUS BLOCK	NTS
DATE	14.03.11	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

APPROVED